

0 200-665-019

# Work Order ID 78377

\*78377\*

Page 1

January-12-12 7:45:58 AM

Item ID: D4445-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Cable Guard

Start Date: 1/06/12 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 1/20/12 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4445

A

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D4445

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

12-1-12

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

12-1-12

# Work Order ID 78377

**\*78377\***

Page 2

January-12-12 7:45:58 AM

Item ID: D4445-1

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Cable Guard

Start Date: 1/06/12

Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 1/20/12

Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Run Start

**\*NR1\***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

**\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

**\*120\***

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Mill as per folio FB072 & dwg D4445,  
FOLIO REV: 4A  
DWG REV: A  
2-Deburr as required

0.00

0.00

*ml 12/01/17*

*5*

130

**\*130\***

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

*ml 12/01/17*

*5*

140

**\*140\***

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

*SL 12-01-18*

# Work Order ID 78377

**\*78377\***

Page 3

January-12-12 7:45:58 AM

Item ID: D4445-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Cable Guard

Stop **\*NS2\***

Start Date: 1/06/12 Start Qty: 4.00 **\*4\***

Cust Item ID:

Required Date: 1/20/12 Req'd Qty: 4.00 **\*4\***

Customer:

Reference:

Run Start **\*NR1\***

Approvals: Process Plan: Date:

Tooling: Date:

Stop **\*NR2\***

QC: Date:

SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: _____	0.00							
<b>*150*</b>									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

12/1/20 *[Signature]* 4

12/1/23 *[Signature]*

12-01-20 *[Signature]*

# Picklist Print

January-12-12 7:45:58 AM

Page 1

Work Order ID: 78377  
Parent Item: D4445-1  
Parent Item Name: Cable Guard

Start Date: 1/06/12  
Start Qty: 4.00  
Required Date: 1/20/12  
Required Qty: 4.00

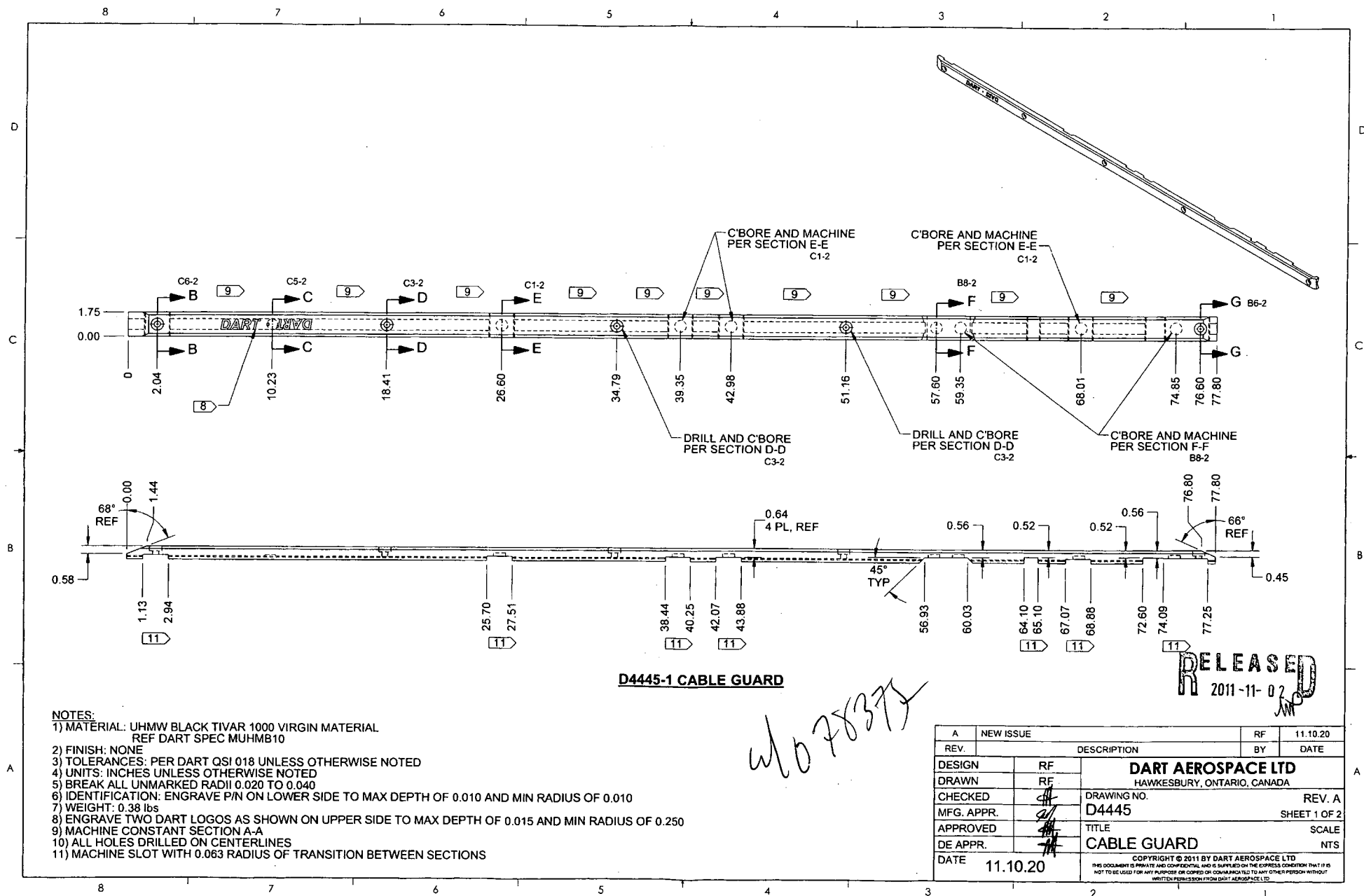
Comments: IPP REV:A 11/10/05 NEW ISSUE JFS VERIFIED BY:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No				sf	455.1443		3.9909726			
UHMW 1" Black													

12-1-12

Location	Loc Qty	Loc Code
MAT018	195.5	
120035	195.5	
MAT019	259.6443158	
117321	74.6	
117738	95.8	
117819	83.3	
118814	1.5	
119145	4.44431579	

120035



8

7

6

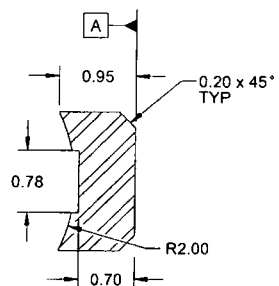
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4

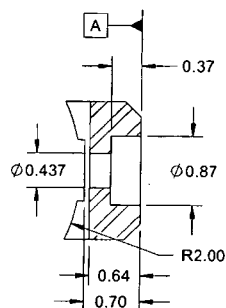
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2

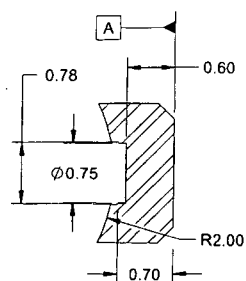
1



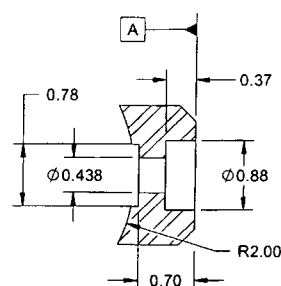
**SECTION A-A** C1-1  
SCALE 3.5X TO C3-1



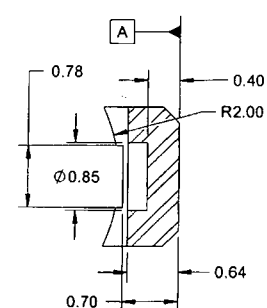
**SECTION B-B** C8-1  
SCALE 3.5X



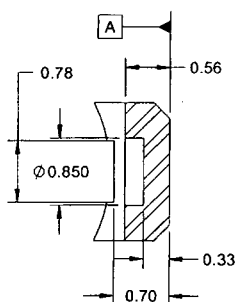
**SECTION C-C** C7-1  
SCALE 3.5X



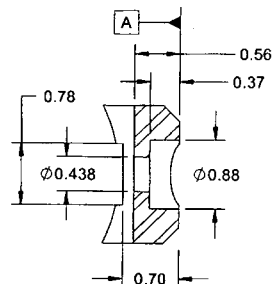
**SECTION D-D** C3-1  
SCALE 3.5X 3 PL C4-1 C6-1



**SECTION E-E** C2-1  
SCALE 3.5X 4 PL C4-1 C5-1 C6-1



**SECTION F-F** C1-1  
SCALE 3.5X 3 PL C3-1



**SECTION G-G** C1-1  
SCALE 3.5X

RELEASED  
2011-11-02

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>RF</del>	DRAWING NO.	REV. A
MFG. APPR.	<del>RF</del>	<b>D4445</b>	SHEET 2 OF 2
APPROVED	<del>RF</del>	TITLE	SCALE
DE APPR.	<del>RF</del>	<b>CABLE GUARD</b>	NTS
DATE	11.10.20	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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8

7

6

5

4

3

2

1

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 78377
<b>Description:</b> CABLE GUARD	<b>Part Number:</b> D4445-1
<b>Inspection Dwg:</b> D4445 Rev: A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.75	$\pm .030$	1.748	—		Vern 91-06	
2.04	$\pm .030$	2.035	—		"	
10.23	$\pm .030$	10.23	—		M-type 91-04	
.58	$\pm .030$	.58	—		Vern 91-06	
1.13	$\pm .030$	1.135	—		"	
2.94	$\pm .030$	2.940	—		"	
.45	$\pm .030$	.450	—		"	
77.80	$\pm .030$	77.800	—		M-type 91-04	
.95	$\pm .030$	.930	—		Vern 91-06	
20X45°	$\pm .030$	200X45°	—		"	
.70	$\pm .030$	.690	—		"	
.78	"	.780	—		"	
Ø.437	$\pm .006$	Ø.438	—		"	
.64	$\pm .030$	.630	—		"	
Ø.82	$\pm .030$	Ø.876	—		"	
.37	$\pm .030$	.370	—		"	
Ø.75	"	Ø.750	—		"	
.60	$\pm .030$	.606	—		"	
Ø.438	$\pm .006$	Ø.438	—		"	
Ø.88	$\pm .030$	Ø.875	—		"	
Ø.85	$\pm .030$	Ø.855	—		"	
.400	$\pm .030$	.405	—		"	
.56	$\pm .030$	.560	—			

<b>Measured by:</b> <i>amf</i>	<b>Audited by:</b> <i>SL</i>	<b>Preliminary Approval:</b>
<b>Date:</b> 12/01/17	<b>Date:</b> 12-01-18	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

*10.04.15*